Work Order ID 105146 Page 1 Tuesday, July 23, 2013 3:46:18 PM D3884-1 Accept Item ID: Setup \*N900040100\* Start Revision 1D: Saddle, Inboard LH Item Name: Start Qty: 2.00 7/23/2013 Cust Item ID: Start Date: Required Date: 7/26/2013 Req'd Qty: 2.00 **Customer:** REWORK Reference: Run Date: 13-7-24 MY. Process Plan: Tooling: Date: Approvals: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Reject Insp. Tool # Plan Accept Code Qty -Qty Number Stamp Work Center ID Description Run Hours Revision Nbr **Draw Nbr** D3884 В 180 0.00 S 12/12/15 \*180\* 0.00 QC Memo PULL FROM STOCK D3884-1 X 2 B#91551 PER RA 111452 Quality Control STRIP AND RE-POWDERCOAT 190 Chemical Conversion Coat per QS1005 4.1 0.00 NG 13-8:16 \*100\* HandFinish 0.00Memo STRIP AND RE-ALODINE Hand Finishing 2X / m-/ 13/08/20 QC7-Inspect Chemical Conversion Coat 0.00 200 \*200\* 0.00 QC Memo -Quality Control

WCR:	Yes	/	No
TYCIL.	163	,	NU

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA:	(	)ate:		

										QA Closed:	Dat	e:
Work Orde	r:	· · · · · · · · · · · · · · · · · · ·			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.  NCR No.					Rework Scrap Use-as-is		Machining Small Fab Thermoforming Finishing		Crosstube Small Fab Finishing	Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR N	lo				Work Order Update	J		Large Fab	Composite	<u>,</u>	Supplier	
Root				Descri	iption of work order update	lni	tial	Ad	ction	Sign &		
Cause	Date	Step	Qty	1	or Non-conformance	Chie	f Eng	Desc	cription	Date	Verification	n QC Inspector
Doc/Data Equip/Tooling Operator Material					<b></b>							
Setup												
Other												
Process												
Supplier												
Training												
Unapproved	7											
•			•——•		F	AULT	CATE	GORY	·			
Landir	ng Gear				General				<u> </u>	_		
	Bending				Bend	G	rain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to C	o/s	BOM/Route	Н	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	ln	specti	on Incomplete		Part Incorred	ct	Weld
{	Crushed/	Crimped			Burrs	∐ In	struct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	<u></u>	lainte	nance		Part Moved		
	Heat Trea	at			Countersink	Шм	lislabe	led		Positioned W	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short	∐~	lisread		Ŀ	Power Loss/	Surge	Other
	Ripples in				Drill Holes		ffset					<u> </u>
	Torque W	Vaves in E	xtrusion	· L	Drawing	$\vdash$		Calibration				·
	Turning S	equence			Finísh	$\square$ $\circ$	ut of S	equence				
	Wave/Twist in Tube Folio						utside	Dimensions				

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Work Ord				*10!		Page 2			
Item ID: Revision ID: Item Name:	D3884-1 Saddle, Inboa	rd LH	<u> </u>	Accept	*N900040	1100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	7/23/2013 7/26/2013 REWORK	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:				
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 210 *210* Powdercoat Powder Coating  M\ Q6 220 *220*	,	Operation Description White Gloss(Ref:4.3.5.1  Memo START TIM OVEN TEM FINISH TIM	ME: MPERATURE: 3 ME:  12 1	Set Up/ Run Hours 0.00 (450.00 20) 1	Tool ID Tool	Code Qty		, D	Reject Insp. Number Stamp
QC Quality Control		Memo  Identify as per dwg & Si	tock Location	0.00 35 A <sub>0.00</sub>			21	þ	Il 13/08/2
*230* Packaging Packaging		Memo		0.00		-	29		30138

		DQA:	Date:	
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									QA Closed:	Dat	te:
Work Orde					DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
	lo				Rework Scrap Use-as-is Work Order Update	4 8	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other	
Root		T		Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Des	cription	Date	Verification	n QC Inspector
Doc/Data					· · · · · · · · · · · · · · · · · · ·						_
Equip/Tooling			li								
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	Bending				Bend	Grain		<u></u>	Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to C	)/S	BOM/Route	Hardwa		<u></u>	Over/Under	ŀ	Temperature/Cure
	Cracks				Broken/Damaged		ion Incomplete	<u></u>	Part Incorre	}-	Weld
	Crushed	/Crimped			Burrs	-	tions Incomplete	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Tre				Countersink	Mislab		_	Positioned V		<b>-</b>
	<b>—</b>	on Strip in	Tube	_	Cut Too Short	Misrea	d	L_	Power Loss/	Surge	Other
·	Ripples i			<u> </u>	Drill Holes	Offset					
		Waves in I		·  _	Drawing	$\vdash$	Calibration				
	Turning	Sequence	!		Finish	<b>}4</b>	Sequence				·
	Wave/Twist in Tube Folio					I lOutside	Outside Dimensions				

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Work Order ID 105146 Page 3 Tuesday, July 23, 2013 3:46:18 PM Item ID: D3884-1 Accept \*N900040100\* Setup Start **Revision ID:** Stop Saddle, Inboard LH Item Name: Start Oty: 2.00 7/23/2013 Start Date: Cust Item ID: Required Date: 7/26/2013 Reg'd Oty: 2.00 **Customer:** Reference: REWORK Start Run Process Plan: Date: **Tooling:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Set Up/ Tool ID Tool# Plan Accept Reject Operation Reject Insp. Work Center ID Code Qty Qty Number Stamp Description **Run Hours** 240 QC21- Final Inspection - Work Order Release 0.00 MB18171 \*240\* QĈ 0.00 Memo

Quality Control

DQA:	Date:	

## MODE ODDED NON CONFORMANCE / HIDDATE

NCR: Y	es / No				WORK ORDER NOW	-00	NONI	MANUE / OF		QA Closed:	Date:		
Work Orde					DISPOSITION	<u>-</u>			AGAINST DE	PARTMENT,	/PROCESS		
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	lo								Finishing Composite				
Root				Descri	iption of work order update		Initial	Ac	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	C	nief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data			[										
quip/Tooling	[						i i		!				
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Setup						- 1							
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Fraining		1	]										
Jnapproved		<u> </u>			<u> </u>		_			<u> </u>			
						FAU	LT CATE	GORY					
Landin	ng Gear			_	General		٦			1		1	
	Bending			.  -	Bend		Grain		<u> </u>	Ovalized	_	Pressure/Forced	
	Centre N	ot Concei	ntric to C	<sup>)/S</sup>	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under	· · · · · · · · · · · · · · · · · · ·	Temperature/Cure	
}	Cracks			<u> </u>	Broken/Damaged	-	4	on incomplete	<u> </u>	Part Incorre	<del></del>	Weld	
ļ	Crushed/	'Crimped			Burrs	<u> </u>	-{	ions Incomplete/	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled	
	Cuffs			<u> </u>	Contamination	$\vdash$	Mainte		<u> </u>	Part Moved			
	Heat Trea			-	Countersink		Mislabe		<u> </u>	Positioned V	_	1	
}	Inspectio		Tube	<u> </u>	Cut Too Short	<u> </u>	Misread	I		Power Loss/	Surge	Other	
	Ripples in			<u> </u>	Drill Holes	$\vdash$	Offset					·	
	Torque V			<u> </u>	Drawing	$\vdash$	-i	Calibration					
	Turning S	•		$\vdash$	Finish	$\perp$	╡	Sequence					
	Wave/Tw	vist in Tul	oe e		Folio		Outside	Dimensions					

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Tuesday, July 23, 2013 3:46:18 PM

Work Order ID:

105146

Parent Item:

D3884-1

Parent Item Name:

Saddle, Inboard LH

Comments:

IPP RevA: New issue DD verified by:EC

Start Date: 7/23/2013

Required Date: 7/26/2013

Start Qty: 2.00

Required Qty: 2.00

Component Item 1D/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	1
D3884-I		Manufactured	No				Each	19.0000	· -	2	. ,		- · · ·—	•
Saddle, Inboard LH												<del>-</del>	<del></del>	<b>-</b> i
				Location		Loc Qtv	<u>Lo</u>	c Code						
				ST429		13								1
				1015	17	6								
				1023	52	7								
				ST430		6								
				1007	86	6								

2 x 91551.

			DQA:	Date:	
ICD.	Ves / No	WORK ORDER NON-CONFORMANCE / LIPDATE	<del></del>		

NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Water Jet Engineering Rework Skid-tube Crosstube Prod. Eng. Coor. Quality Machining Part No. Small Fab Scrap Use-as-is Thermoforming Finishing Rec/Store/Packaging Other NCR No. Supplier Work Order Update Large Fab Composite Description of work order update Sign & Initial Action Root Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Cause Date Step Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bending Bend Grain Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Broken/Damaged Weld Part Incorrect Cracks Inspection incomplete Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Maintenance Part Moved Cuffs Contamination Countersink Mislabeled Positioned Wrong Heat Treat Other Cut Too Short Misread Power Loss/Surge Inspection Strip in Tube **Drill Holes** Offset Ripples in Bend

**Out of Calibration** 

Out of Sequence

**Outside Dimensions** 

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

## RA 111452 D119-646-211 B91555

Received @ Dart December 18th, 2012 Inspected@ Dart December 19th, 2012

Customer: AGUSTA WESTLAND Customer Contact: MATTHEW PIAZZA Shipped from: PHILADELPHIA PA, USA

## Instructions for RA111452 D119-646-211 B91555 CHG003

- Remove both wear plates D3849-041 & D3849-043 and return back to stock under-new batch #'s no reworks needed Critical Porton Marries
- D119-646-241 B91574 was returned
- Out of the kit only these D parts were returned
  - MUST BE RETURNED TO STOCK UNDER NEW BATCH #'S
  - Only D3884-1 B91551 qty x2 returned
    - Needs powder coat striped and re powder coated
  - Only D3883-1 B88530 qty x2 returned
    - Needs powder coat striped and re powder coated
  - Only D3407-041 B88212 qty x1 returned
    - Needs powder coat striped and re powder coated
  - o Only D3886-041 B88235 qty x2 was returned form D119-646-311 B87632
    - Needs powder coat striped and re powder coated
  - No hardware was returned
- D119-646-241 B91574 saddles do not align and could be saved by approved re work scheme that must be approved by David Shepard or skid tube is scraped

<u>Time Estimate =? HOUR ONLY (stores)</u>

**Departments Required:** Stores (restocking)

<u>Pictures Attached</u> = YES

**QTY INSPECTED** = QTY x1 D119-646-241 and some D parts

THIS INSTRUCTION SHEET MUST BE ATTACHED TO THE RESTOCKING WORK ORDER AT ALL TIMES!!!!

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